

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000276**Date Inspected:** 10-Jul-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	WQT		

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Bruce Berger was present to observe quality control functions related to welding, testing and fabrication procedures at the Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Caltrans Quality Assurance (QA) Inspector Bruce J. Berger observed welder qualification testing (WQT) by Moody International Inspectors Feng Lin Yao, Tang Li Pang, Zhou Daqing and He Jia Min at ZPMC today. There was one ZPMC Certified Welding Inspector, Xu Xian Ping with four assistants and one American Bridge/Fluor employee Mr. Danny McDonald. There were a total of 40 welders which attempted welder qualification test for yesterday in the shield metal arc (SMAW), submerged arc (SAW) and the flux cored arc (FCAW) welding process.

There were of total of 24 FCAW welder tests attempted with only 7 passing final visual inspection, and a total of 12 SMAW tests attempted with only 7 passing final visual inspection and a total of 4 SAW tests attempted with 3 passing final visual inspection. Moody International Certified Welding Inspector Zhou Daqing performed the final visual inspections. Both the Moody International and ZPMC inspectors were observed checking the welding parameters for the welders being tested. A random inspection was made of the various volt/amp gauges and temperature gauges for calibration of which all were found to be in a current state of calibration.

Radiographic Film Review: This Quality Assurance Inspector reviewed 98 films for welder qualification test for complete butt joint penetration weld. This Quality Assurance Inspector found an additional three welds which appeared to not be in compliance with the code.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Moody International CWI, Zhou Daqing checking amperage of welder qualification test at ZPMC on Changxing Island.



ZPMC QA's and ABF Inspector observing the welding qualification testing at the ZPMC Facility



Summary of Conversations:

No relevant conversations took place on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger, Bruce	Quality Assurance Inspector
Reviewed By:	McClary, David	QA Reviewer
